

# Work Order ID 60436

Wednesday, July 07, 2010 2:57:53 PM



Page 1

Item ID: D412-705-017

Accept



Setup Start



Revision ID:

Item Name: N1 Gearbox Access Panel

Stop



Start Date: 7/7/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: *mf*

Date: *10-7-7*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3255	Rev B								

100



DOCUMENT CONTROL

0.00

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD412-705-017

CHG001

*Solashu*

*After BG 10/07/22*

110



Pick Kit

0.00

Packaging

Memo

0.00

Packaging

*10-7-26*

120



QC4- 100% Inspect kits for completeness

0.00

QC

Memo

0.00

Quality Control

*Solashu*

*(+2)*

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 60436**

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Item ID: D412-705-017

Accept



Setup Start



Revision ID:

Stop



Item Name: N1 Gearbox Access Panel

Start Date: 7/7/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 7/21/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Packaging

Packaging

0.00

Memo

0.00

Identify and pack for shipping as per PPP D412-705-017 Location: 31 A □ PPP Rev: A

10-7-26

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/07/26

14-10-7-26  
(2)

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

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Work Order ID: 60436

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 7/7/2010

Required Date: 7/21/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:C Removed Manufacturing 06-08-02 JLM  
IPP Rev:D ECN 1052 07-11-06 DD verified by: EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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AN3C3A S Bolt		Purchased	No			120	Each	301.0000	30	60			
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Location Loc Qty Loc Code

ST350 301  
111916 101  
113359 200

D3255-041 S Access Panel Assembly		Manufactured	No			120	Each	0.0000	1	2			
--------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

D3255-042 S Access Panel Assembly		Manufactured	No			120	Each	0.0000	1	2			
--------------------------------------	--	--------------	----	--	--	-----	------	--------	---	---	--	--	--

MS20427M3-3 S Rivet		Purchased	No			120	Each	532.0000	36	72			
------------------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location Loc Qty Loc Code

ST318 532  
112933 8  
113064 524

MS21060-L3K S Nut Plate		Purchased	No			120	Each	165.0000	18	36			
----------------------------	--	-----------	----	--	--	-----	------	----------	----	----	--	--	--

Location Loc Qty Loc Code

ST302 165  
113644 5  
115101 160

10.7.26  
B60072 10.7.26  
B60073 10.7.26  
10.7.26  
10.7.26 50 (20)  
36

W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

# Picklist Print

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Page 2

Work Order ID: 60436

Parent Item: D412-705-017

Parent Item Name: N1 Gearbox Access Panel

Start Date: 7/7/2010

Required Date: 7/21/2010

Start Qty: 2.00

Required Qty: 2.00

MS9321-09

Purchased

No

120

Each

153.0000

30 ) 60



Washer



10.7.26

av

Location

Loc Qty

Loc Code

ST296

153

110399

153

60

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Shop Packet Print

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W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Qty -017	Qty -019	Qty -021	Qty -023	Part Number	Description
X							D412-705-011	TWIN PAK E-Z ACCESS KIT
1	X						D412-705-013	INTAKE PLENUM ACCESS PANEL KIT
1		X					D412-705-015	DRIVESHAFT TUNNEL MODIFICATION KIT
1			X				D412-705-017	N1 GEARBOX ACCESS PANEL KIT
1				X			D412-705-019	C-BOX OIL COOLER LINE SUPPORT ACCESS KIT
1					X		D412-705-021	OIL PRESSURE TRANSMITTER ACCESS KIT
1						X	D412-705-023	OIL COOLER SUPPORT REMOVABLE LOWER PANEL KIT
	1						D3245-041	ACCESS PANEL ASSEMBLY, LH
	1						D3245-042	ACCESS PANEL ASSEMBLY, RH
	2						D3245-043	DOOR ASSEMBLY
	2						D3245-9	GASKET
	2						D3245-11	GASKET
	2						D3245-13	GASKET
			1				D3255-041	ACCESS PANEL ASSEMBLY, LH
			1				D3255-042	ACCESS PANEL ASSEMBLY, RH
		1					D3256-1	ACCESS PANEL
		1					D3256-3	GASKET
				1			D3259-041	ACCESS PANEL ASSEMBLY, LH
				1			D3259-042	ACCESS PANEL ASSEMBLY, RH
					1		D3307-041	ACCESS PANEL ASSEMBLY
						30	AN3-3A	BOLT
		22	30		6		AN3C-3A	BOLT
		3					AN3C-4A	BOLT
						30	AN960JD10	WASHER
16	44	36			12		MS20427M3-3	RIVET
						2	MS21051-L3K	NUT PLATE
8	22	18			6		MS21060-L3K	NUT PLATE
						18	MS21069-L3K	NUT PLATE
	25	30			6		MS9321-09	WASHER

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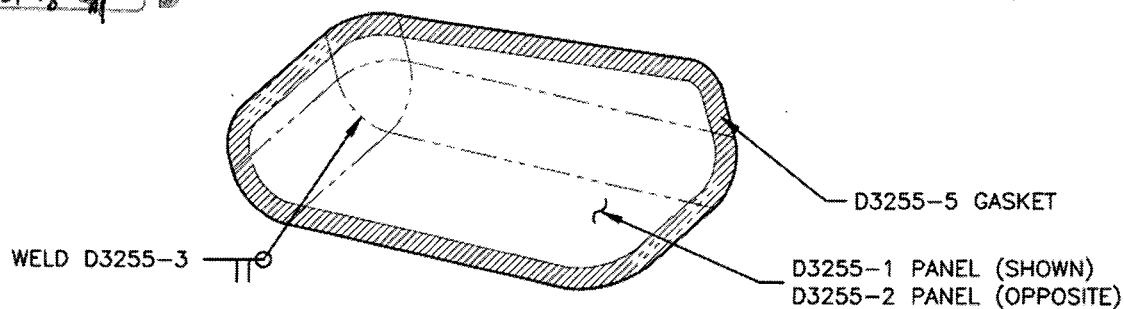
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Date: 07.10.12



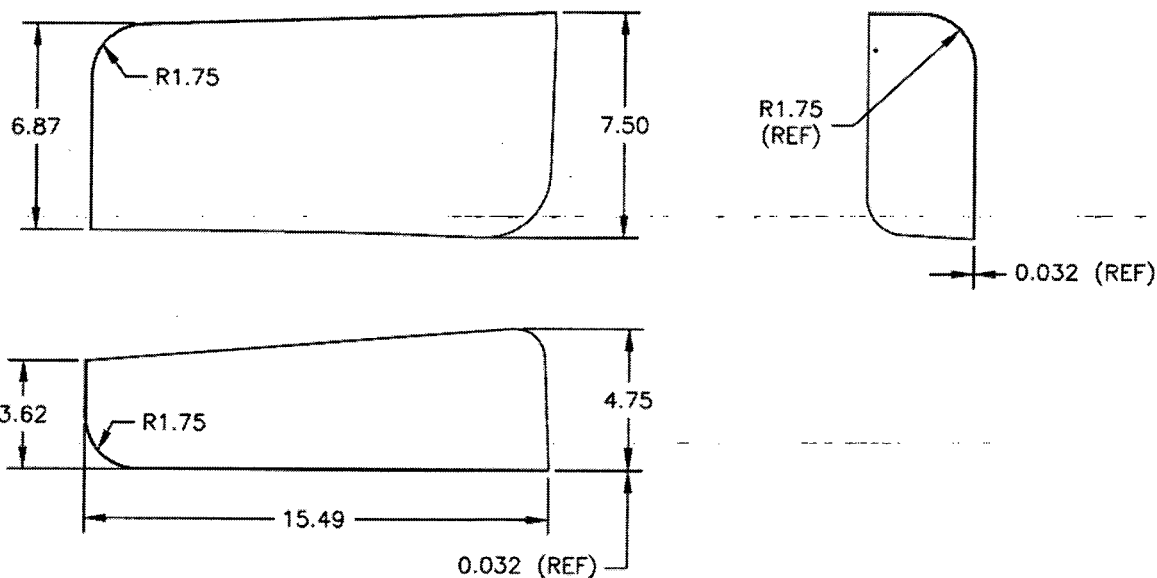
REFERENCE ONLY

DESIGN JH	DRAWN BY JH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JP	APPROVED JH	DRAWING NO. D3255	REV. B SHEET 1 OF 4
DATE 04.12.06		TITLE ACCESS PANEL ASSEMBLY	SCALE 1:6
A	04.01.27	NEW ISSUE	
B	04.12.06	D3255-3 REDESIGN; ADDED $\phi 0.098$	

RELEASED  
05.01.18 #



D3255-041 ACCESS PANEL (SHOWN)  
D3255-042 ACCESS PANEL (OPPOSITE)



D3255-1 BEND-DETAIL  
D3255-2 OPPOSITE

D3255-041/-042 NOTES:

- 1) WELD PER DART QSI 004
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) INSTALL D3255-5 GASKET USING DOW CORNING P/N 736 ADHESIVE IN ACCORDANCE WITH MANUFACTURE'S INSTRUCTIONS
- 4) IDENTIFY WITH P/N & B/N USING FINE POINT PERMANENT MARKER

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